

Work Order ID 70172

Monday, May 30, 2011 1:49:59 PM



Page 1

Item ID: D3391-025

Accept



Setup Start



Revision ID:

Item Name: Aft Tube Assembly

Stop



Start Date: 5/31/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/10/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: MF

Date: 11-05-30

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3391

Rev H/ DEO

100



MORI SEIKI CNC LATHE LARGE

0.00

Mori Seiki

Memo

0.00

Mori Seiki CNC Lathe Large

Turn as per Folio FA599

Rev: 4A & Dwg D3391 Rev: H

MAN.L 11/06/06

scribe batch # on fwd end at 90 degree

110



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

Quality Control

cont 11/06/06

111



QC8- Inspect parts - second check

0.00

QC

Memo

0.00

Quality Control

11-06-06

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item Name: Aft Tube Assembly

Start Date: 5/31/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/10/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



HAAS 1

HAAS CNC VERTICAL MACHINING #1

0.00

smk 11/06/07

~~HAAS 1~~~~HAAS 1~~

1

0

HAAS CNC vertical machine #1

Memo

0.00

1-Machine as per Folio FA 599 Rev: AL & Dwg D3391 Rev: H
2-Deburr

130



QC

QC2- Inspect parts off machine FAI/FAIB

0.00

smk 11/06/07

1

0

Quality Control

Memo

0.00

140



QC

QC8- Inspect parts - second check

0.00

S.A 11/06/08

1

0

Quality Control

Memo

0.00

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150



Skidtubes

Skidtubes

0.00

Memo

0.00

1-Drill (PILOT HOLE) aft cap holes per Dwg D3391 using DT8803

DP

11-6-8

160



CNC Bend 1

BENDING MACHINE - SKIDTUBES

0.00

Memo

0.00

Form as per Dwg D3391 Using Bend Prog 3391025

DP

11-6-8

170



QC

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

H-4.15"

x1 Ø BEI/06/08

Quality Control

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Required Date: 6/10/2011 Req'd Qty: 1.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180



Skidtubes

Skidtubes

Skidtubes

Memo

0.00

1-Open Aft cap pilot hole to .208" as per Dwg D3391

2-Drill float bag holes using DT8809 as per Dwg D3391(Holes marked "A" Only.

3-Drill wearplate holes as per Dwg D3391 using DT8878(Mid Tube) & DT8217
Wearplate Jig

*****Do Not Open To Finished Size*****

4-Drill Wearshoe holes as per DWG D3391 using DT8939 locating from 2
previously drilled aft wearplate holes.

5-Open wearplate holes to 0.250" and c'bore as per dwg D3391

6-Open up all wearshoe, wearplate to 0.297"and float bag holes to 0.328" as per
Dwg D3391.

7-Deburr

BP

11-6-8

11/06/08

W/O:		WORK ORDER CHANGES						
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Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

200

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

210

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

S w l o c l o s



B 11/06/08

DP

11-6-8

W/O:		WORK ORDER CHANGES						
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Cust Item ID:

Required Date: 6/10/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

220



Skidtubes

Skidtubes

0.00

Memo

0.00

Instal spacers as per dwg D3391
A/R Magnabond 6398 Batch: 116677
exp. date: 11/08
cure time 12hrs as per QSI0015

230



QC

Quality Control

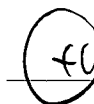
QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

S u 10/6/09



235



HandFinish

Hand Finishing

Pressure Wash per QSI005 4.3

0.00

Memo

0.00

AND REALODINE AS PER PAR09-043

1 BR 11-6-9.

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Item ID: D3391-025

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Start Date: 5/31/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/10/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

240

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Powder Coating

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

10:30
320 °F
11:00

0.00

IX Ø M-11/06/09

250

QC3- Inspect Part Finish

0.00



QC

Memo

Quality Control

1 Ø M-11/06/09

260

HandFinishing

0.00



HandFinish

Memo

1-Install inserts as per Dwg D3391

2-Install Aft Cap as per Dwg D3391

A/R Sikaflex-241/-291 M116945

Sikaflex expiry date: 12/01

0.00

1 Ø M-11/06/09

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

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Work Order ID 70172

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Item ID: D3391-025

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Setup Start



Revision ID:

Stop



Item Name: Aft Tube Assembly

Start Date: 5/31/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/10/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

270

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8 uloclog

AC

280

Identify as per dwg & Stock Location: W10

0.00



Packaging

Memo

0.00

Packaging

D412-742-043/1369244

1 6 24 uloclog

290

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/6/13 JJ
ME
11-06-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

Monday, May 30, 2011 1:49:52 PM

Page 1

Work Order ID: 70172

Parent Item: D3391-025

Parent Item Name: Aft Tube Assembly




Start Date: 5/31/2011

Required Date: 6/10/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev B 06-02-07 ECN773 dwg rev. D EC
 IPP Rev:C 06-03-28 Update Manuf. Instructions JLM □□ □□
 IPP rev D 07.03.20 revF dwg EC
 IPP rev E 07.11.07 rev G dwg ecn 1053p EC verified by: DD
 IPP Rev:F 07-11-13 ECN 1056 DD verified by: EC
 IPP Rev:G 08-09-10 revH as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6014-090  ALUMINUM EXTRUSION		Manufactured	No			100	Each	7.0000	1	1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				LG		7							
				(56572)		7							
D3670-4-200  SPACER		Manufactured	No			230	Each	59.0000	4	4		mm.l 11/6/11	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				LG		59							
				(68950)		59							
D2646  Aft Cap		Manufactured	No			270	Each	36.0000	1	1		4 3B 11/06/08 H 11/06/08	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				FP006		35							
				62678		35							
				FP-4		1							
				69019		1							

W/O:		WORK ORDER CHANGES						
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Page 2

Work Order ID: 70172

Parent Item: D3391-025



Parent Item Name: Aft Tube Assembly

Start Date: 5/31/2011

Required Date: 6/10/2011



Start Qty: 1.00

Required Qty: 1.00

D3537-1 Manufactured No 270 Each 6.0000 1 1
  all ulowlog
 Wearpad



Location Loc Qty Loc Code

FP017 6
 63313 2
 66935 4 368944

D3537-7 Manufactured No 270 Each 4.0000 1 1
  all ulowlog
 Wearpad



Location Loc Qty Loc Code

FP017 4
 65146 4 36

D3553-1 Manufactured No 270 Each 16.0000 1 1
  all ulowlog
 Gasket

Location Loc Qty Loc Code

FP013 16
 56568 16 36

D3553-3 Manufactured No 270 Each 40.0000 1 1
  all ulowlog
 Gasket

Location Loc Qty Loc Code

FP 20
 31631 20
 FP013 20
 53480 20 36

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Shop Packet Print

Page 2

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Parent Item Name: Aft Tube Assembly

Start Date: 5/31/2011

Required Date: 6/10/2011

Start Qty: 1.00

Required Qty: 1.00

D3672-1
Phenolic Washer

Manufactured No

270 Each

1,204.000 2 2

Location

Loc Qty

Loc Code

ST074

1204

64177

704

66821

500

ALS4-1032-130
Insert

Purchased No

260 Each

2,232.000 14 14

Location

Loc Qty

Loc Code

ST281

242

117331

242

ST282

1990

117717

1990

ALS4-1032-225
Insert

Purchased No

270 Each

1,437.000 12 12

Location

Loc Qty

Loc Code

ST282

1437

110768

637

117717

800

AN3C4A
BOLT

Purchased No

270 Each

2,361.000 6 6

Location

Loc Qty

Loc Code

ST350

2361

117094

955

117313

106

117688

800

117795

500

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Shop Packet Print

Page 3

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Parent Item Name: Aft Tube Assembly

Start Date: 5/31/2011

Required Date: 6/10/2011

Start Qty: 1.00

Required Qty: 1.00

AN3C5A

Purchased

No

270

Each

1,384.000

4

4



Bolt



all 11 104109

Location

Loc Qty

Loc Code

FP-A

7

115835

7

ST350

1377

116419

220

116549

57

117343

500

117508

300

117764

300

X 4

AN960C10L

NAS1149C0332

Purchased

No

270

Each

0.0000

10

10



washer

11 117291



(x10) all 1104109

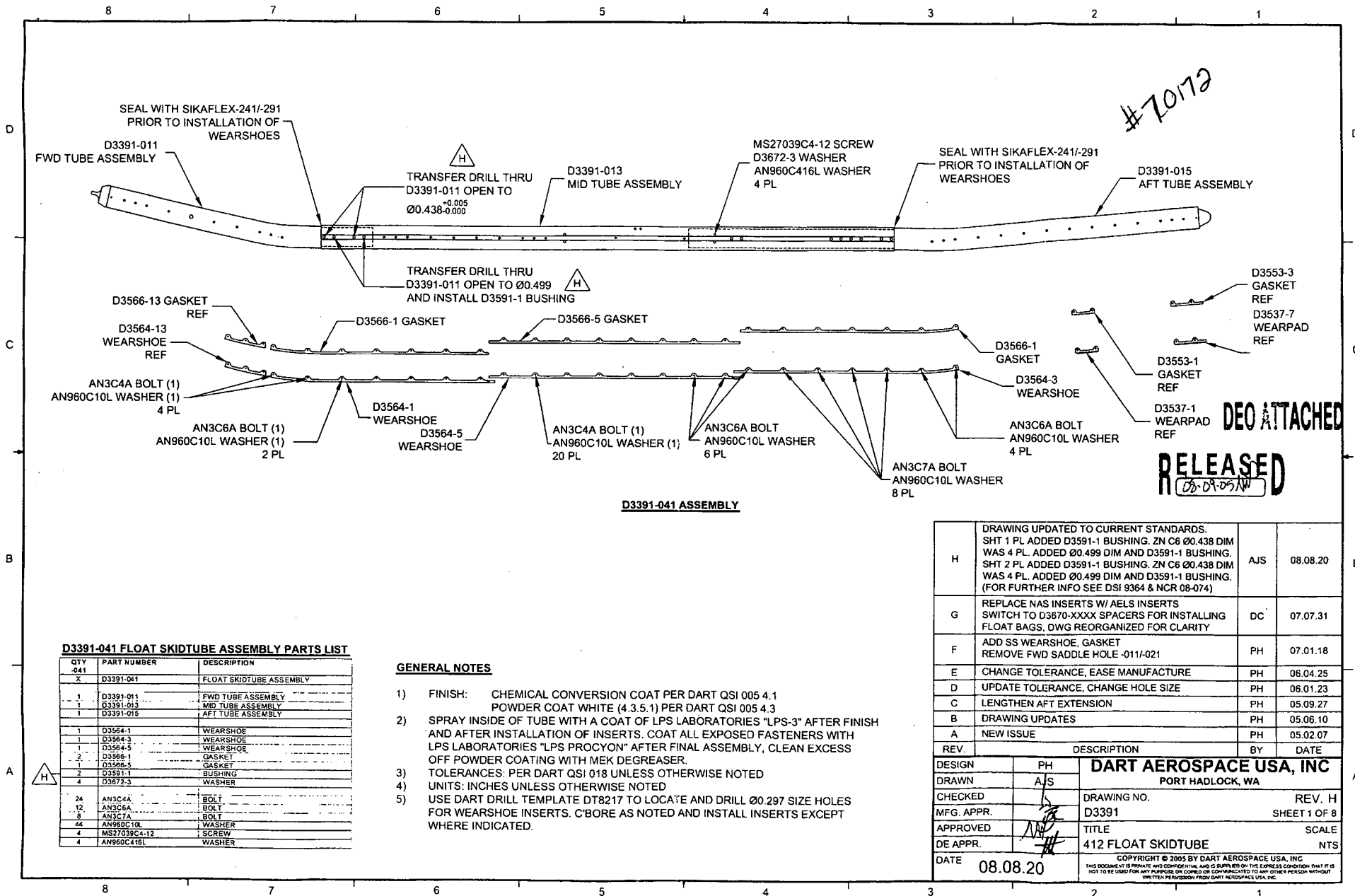
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SEAL WITH SIKAFLEX-241/-291
PRIOR TO INSTALLATION OF
WEARSHOES

D3391-021
FWD TUBE ASSEMBLY

TRANSFER DRILL THRU
D3391-021 OPEN TO
+0.005
Ø0.438-0.000

D3391-023
MID TUBE ASSEMBLY

SEAL WITH SIKAFLEX-241/-291
PRIOR TO INSTALLATION OF
WEARSHOES

D3391-025
AFT TUBE ASSEMBLY

TRANSFER DRILL THRU
D3391-021 OPEN TO Ø0.499
AND INSTALL D3591-1 BUSHING

D3566-13 GASKET
REF

D3564-13
WEARSHOE
REF

D3566-1 GASKET

D3566-5 GASKET

D3566-1
GASKET

D3564-3
WEARSHOE

D3553-3
GASKET
REF

D3537-7
WEARPAD
REF

D3553-1
GASKET
REF
D3537-1
WEARPAD
REF

AN3C4A BOLT
AN960C10L WASHER
4 PL

AN3C6A BOLT
AN960C10L WASHER
2 PL

D3564-1
WEARSHOE
D3564-5
WEARSHOE

AN3C4A BOLT
AN960C10L WASHER
20 PL

AN3C6A BOLT
AN960C10L WASHER
6 PL

AN3C7A BOLT
AN960C10L WASHER
8 PL

AN3C6A BOLT
AN960C10L WASHER
4 PL

D3391-043 ASSEMBLY

D3391-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
X	D3391-043	FLOAT SKIDTUBE ASSEMBLY
1	D3391-021	FWD TUBE ASSEMBLY
1	D3391-023	MID TUBE ASSEMBLY
1	D3391-025	AFT TUBE ASSEMBLY
1	D3564-1	WEARSHOE
1	D3564-3	WEARSHOE
1	D3564-5	WEARSHOE
2	D3566-1	GASKET
1	D3566-5	GASKET
2	D3591-1	BUSHING
24	AN3C4A	BOLT
12	AN3C6A	BOLT
8	AN3C7A	BOLT
44	AN960C10L	WASHER

GENERAL NOTES

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH
AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH
LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS
OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES
FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT
WHERE INDICATED.

DEO ATTACHED

RELEASED
03-01-25/10

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. H
MFG. APPR.	<i>[Signature]</i>	D3391	SHEET 2 OF 8
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	412 FLOAT SKIDTUBE	NTS
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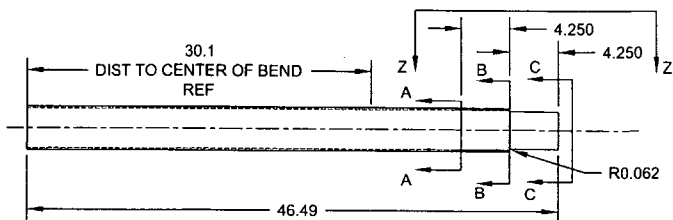
W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

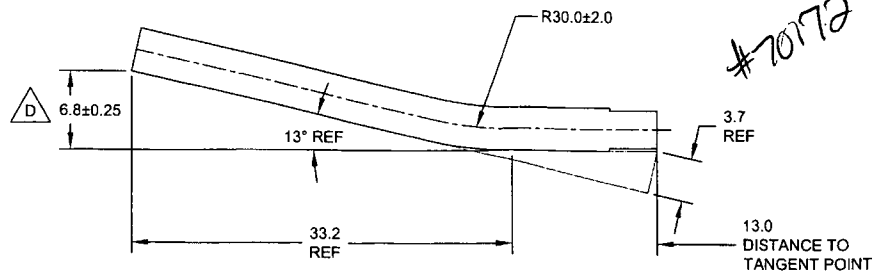
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

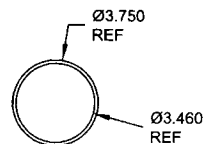
NOTE: Date & initial all entries



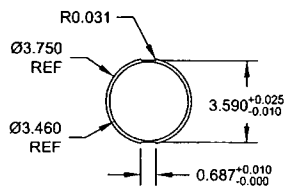
D3391-1 CUTTING DETAIL
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



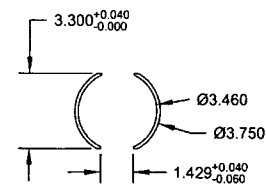
D3391-011/-021 BENDING DETAIL
(MAKE FROM D3391-1)



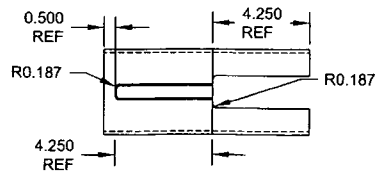
SECTION A-A
SCALE 2X



SECTION B-B
SCALE 2X



SECTION C-C
SCALE 2X



VIEW Z-Z
SCALE 2X

DEO ATTACHED
RELEASED
08-05-11

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MFG. APPR.		TITLE	SHEET 3 OF 8
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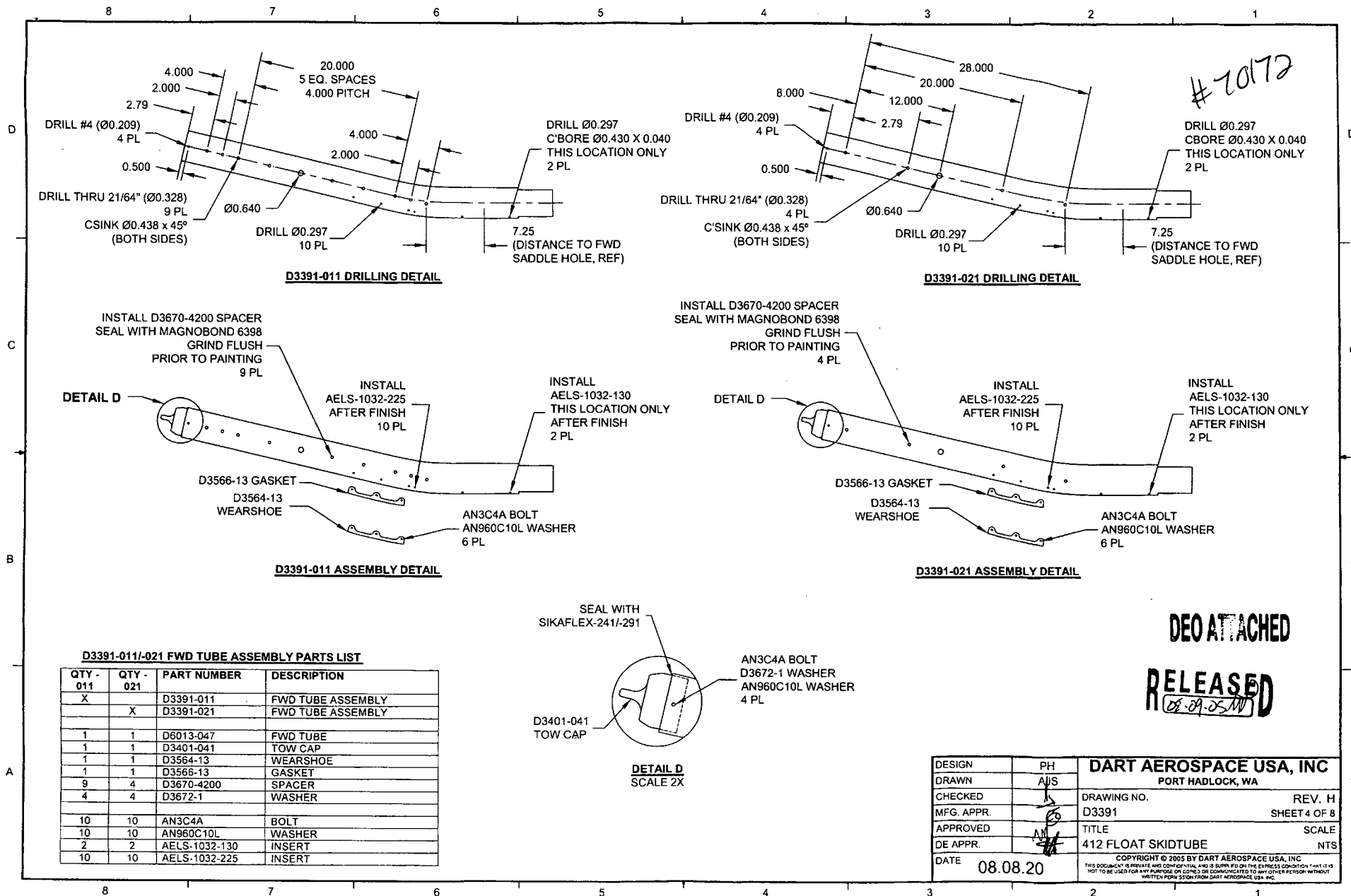
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



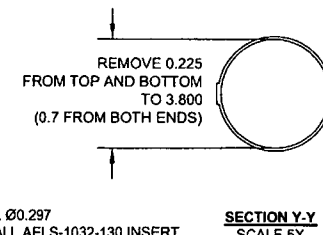
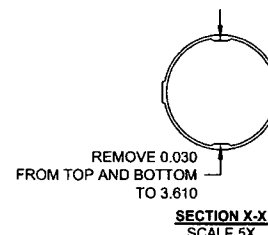
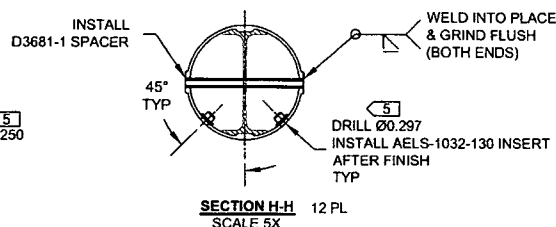
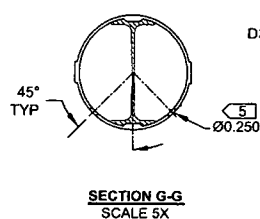
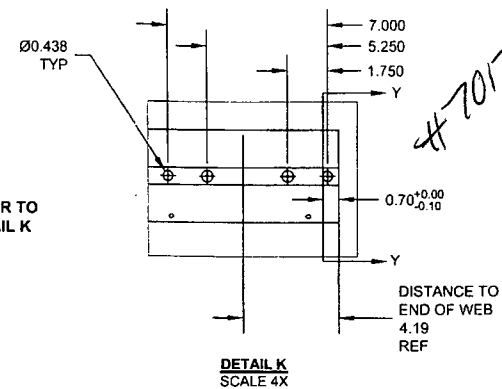
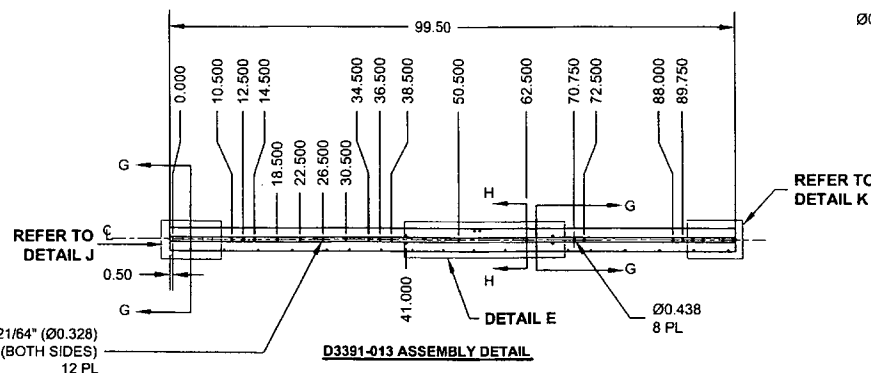
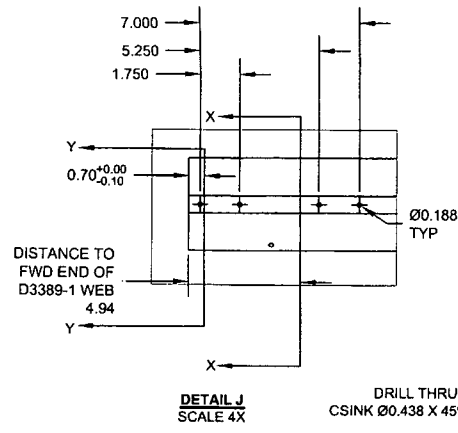
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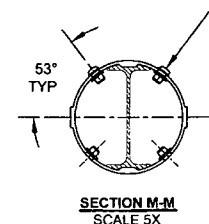
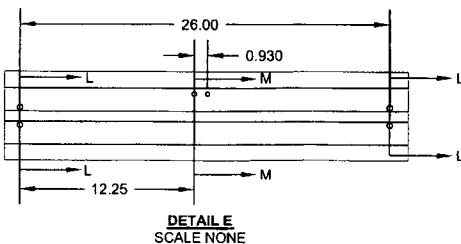
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



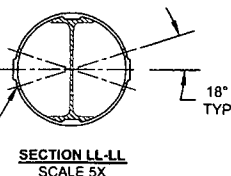
D3391-013 MID TUBE ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
-013		
X	D3391-013	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
4	D3672-1	WASHER
4	D3672-3	WASHER
12	D3681-1	SPACER
24	AELS-1032-130	INSERT
4	ALS4-428-165	INSERT
4	AN960C10L	WASHER
4	AN960C416L	WASHER
4	MS27039C1-09	SCREW
4	MS27039C4-08	SCREW



DRILL Ø0.297
INSTALL AELS-1032-130 INSERT
MS27039C1-09 SCREW
D3672-1 WASHER
AN960C10L WASHER
AFTER FINISH
4 PL

DRILL Ø0.250
4 PL



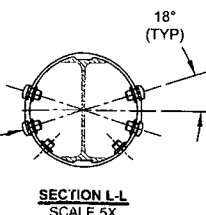
DEO ATTACHED

RELEASED

D3391-013 MID TUBE ASSEMBLY

- MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/291 PER QSI 015
- WELDING: PER DART QSI 004

DRILL Ø0.391
INSTALL ALS4-428-165 INSERT
MS27039C4-08 SCREW
D3672-3 WASHER
AN960C416L WASHER
AFTER FINISH
4 PL



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MFG. APPR.		D3391	SHEET 5 OF 8
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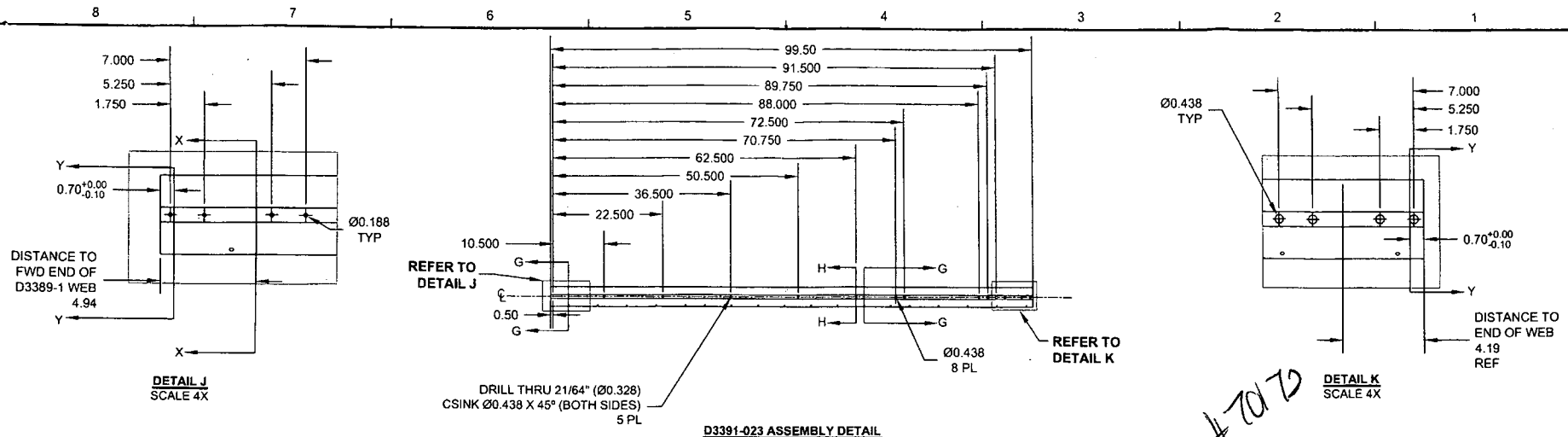
W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

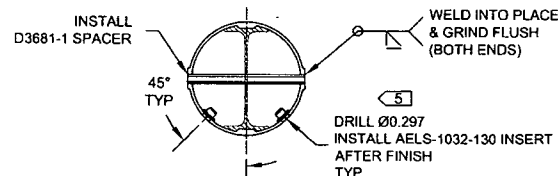
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

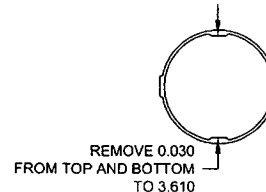
NOTE: Date & initial all entries



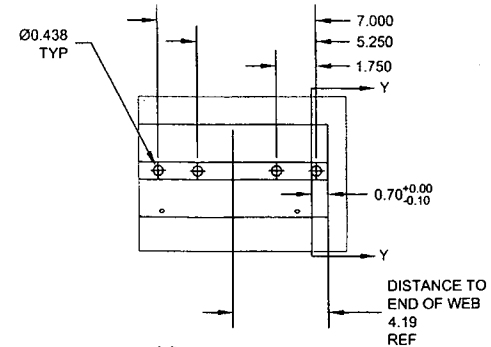
SECTION G-G
SCALE 5X



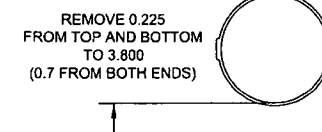
SECTION H-H
SCALE 5X



SECTION X-X
SCALE 5X



DETAIL K
SCALE 4X



SECTION Y-Y
SCALE 5X

D3391-023 MID TUBE ASSEMBLY PARTS LIST

QTY - 023	PART NUMBER	DESCRIPTION
X	D3391-023	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
5	D3681-1	SPACER
20	AELS-1032-130	INSERT

D3391-023 MID TUBE ASSEMBLY

- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/-291 PER QSI 015
- 3) WELDING: PER DART QSI 004

DESIGN	PH	DART AEROSPACE USA, INC	
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08-08-20

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

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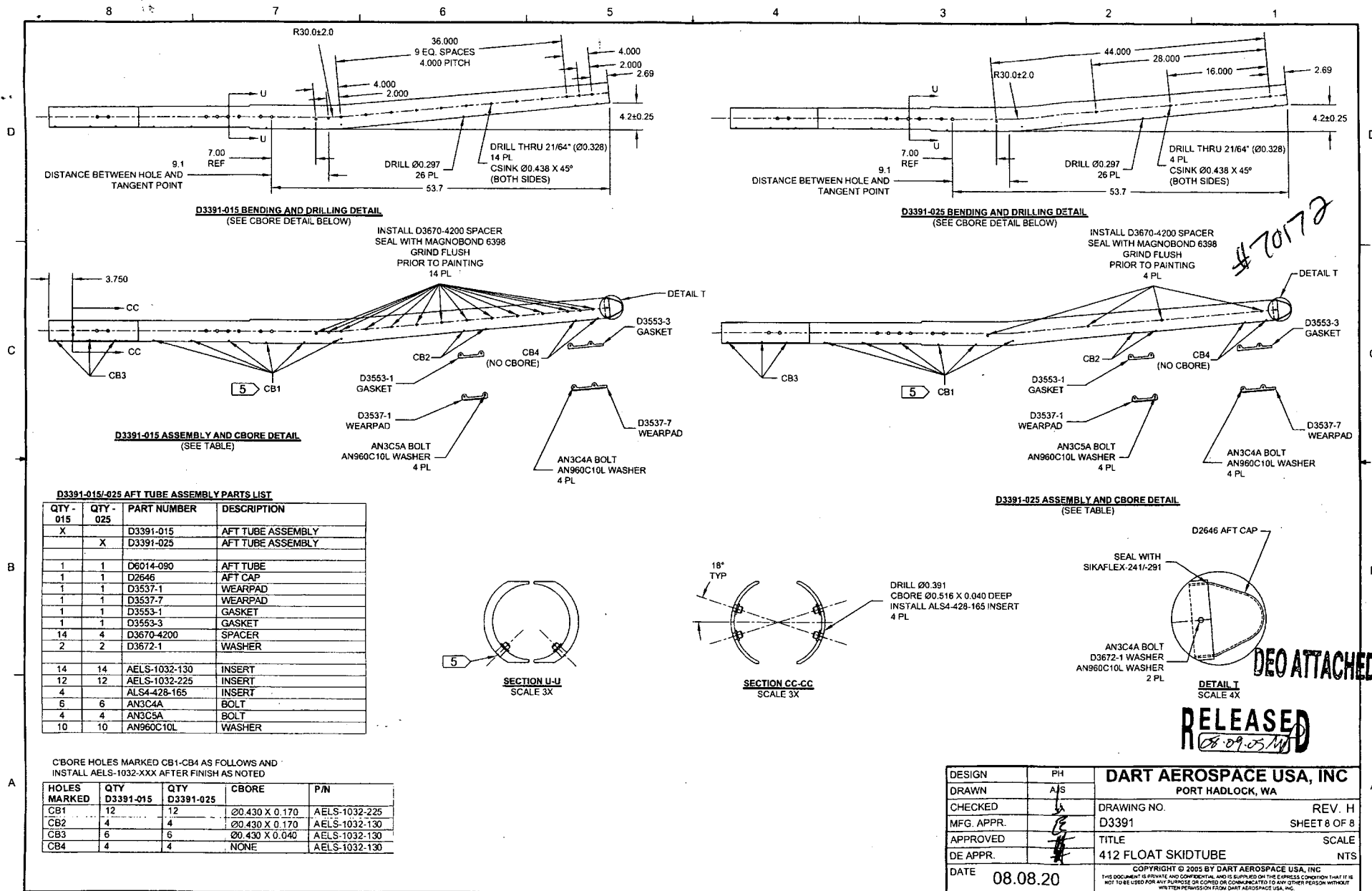
W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries



W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DRAWING NO. D3391	TITLE 412 FLOAT SKIDTUBE	REV. H	DART AEROSPACE USA, INC ENGINEERING ORDER		D.E.O. NO. D3391-H-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>UP</i>	CHECKED <i>h</i>	MFG. APPR. <i>AA</i>	APPROVED <i>MP</i>		DE APPR. <i>h</i>		
DATE 09.09.23	DATE <i>06.04.24</i>	DATE <i>09/09/25</i>	DATE <i>09/09/30</i>		DATE <i>09/09/30</i>		

PURPOSE:

LPS-3 IS NO LONGER USED DURING ASSEMBLY OF D3391-041/-043 SKIDTUBES.

CHANGE:

AMEND NOTE 2 OF D3391-041/-043 SKIDTUBE ASSEMBLIES (ZN A6-1, A6-2) AS FOLLOWS:

- 2) ~~SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH~~
~~AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH~~
 LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS
 OFF POWDER COATING WITH MEK DEGREASER.

RELEASED
 2010-02-02

MP

#70172

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: <i>20172</i>
Description: Float Skidtube (412)		Part Number: D3391-3
Inspection Dwg: D3391	Rev: H	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Lathe Section						
14.000	+/-0.010	14.000	✓		tape	EC-11
3.500	+/-0.010	3.501	✓		vern	JF-01
88.93	+/-0.030	88.93	✓		tape	EC-11
44.995	+/-0.030	44.995	✓		tape	mm. 02
Ø3.200	+/-0.010	3.199	✓		mic	CNC-05
88.93	+/-0.030	88.93	✓		tape	EC-11
Ø3.750	+/-0.010	3.744	✓		mic	CNC-05
30° x 160" chamfer	+/-0.010	30° x 160	✓			

Measured by: <i>AMC/L Jone</i>	Date: 11/06/03
Audited by: <i>[Signature]</i>	Date: 11/06/06

HAAS Section						
1.526	+0.000/-0.030		1.520	✓	Vern H1-7	
7.500	+/-0.010		7.500	✓	"	
27.750	+/-0.010		27.750	✓	M-tape H1-2	
31.750	+/-0.010		31.750	✓	"	
35.250	+/-0.010		35.250	✓	"	
3.300	+/-0.010		3.307	✓	Vern H1-7	
0.200	+/-0.010		0.204	✓	"	
3.520	+/-0.010		3.524	✓	"	
0.687	+0.010/-0.000		0.687	✓	"	
R0.062	+/-0.010		R0.062	✓	R-6	
Ø0.484	+0.005/-0.001		0.489	✓	Vern H1-7	

Measured by: <i>AMC</i>	Date: 11/06/08
Audited by: <i>B.A.</i>	Date: 11/06/08

Rev	Date	Change	Revised by	Approved
A	06.04.24	New Issue P/O D3391-015/-025	KJ/JLM	
B	06.06.19	Dwg revision update	KJ/JLM	
C	07.04.20	Ø0.208 dimension removed	KJ/JLM	
D	07.09.06	0.400 dimension removed	KJ/JLM	
E	07.11.23	Dwg Rev. updated	KJ/EC/DD	
F	09.04.27	Dimensions updated per Rev H and NCR09-028	KJ/JLM	
G	09.11.16	Dimension 0.200 removed	KJ	<i>[Signature]</i>

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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E: Date & initial all entries